

Work Order ID 65311

Tuesday, January 11, 2011 10:26:11 AM

Page 1

Item ID: D4034-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib

Start Date: 1/12/2011 Start Qty: 3.00

Cust Item ID:

Required Date: 1/17/2011 Req'd Qty: 3.00

Customer:

Reference:

Approvals:

Process Plan: mf

Date: 11-01-11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4034

A

100

0.00

Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D4034
2- Drill hole as per dwg using DT9561

SAD
11-01-13

3

110

QC5- Inspect part completeness to step on W/O

0.00

QC

QC6

Memo

0.00

Quality Control

S. 11/01/14

3

Pto →

120

Identify as per dwg & Stock Location: WA

0.00

Packaging

Memo

0.00

Packaging

SAD
10-01-14

3

W/O: 65311		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/14/14	#110	perm. change change QLS to QLG inspection	AA	11.01.17			S 11/14/14	

Part No: D4034-5 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65311

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Page 2

Item ID: D4034-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 1/12/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 1/17/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/01/11

A. Lindley

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, January 11, 2011 10:26:11 AM

Page 1

Work Order ID: 65311

Parent Item: D4034-5

Parent Item Name: Rib



Start Date: 1/12/2011

Required Date: 1/17/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049 		Purchased		No		100	f	307.8119	1.4375	4.539474			
304 SQ Tube .75x.75x.049W													



SAD 11-07-13

Location	Loc Qty	Loc Code
MAT	255.9156679	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	127.7653	
116509	120	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	51.8962	
114992	18.6511	
115260	33.2451	

4.5394

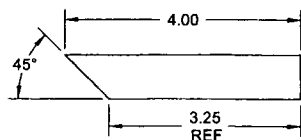
W/O:		WORK ORDER CHANGES					
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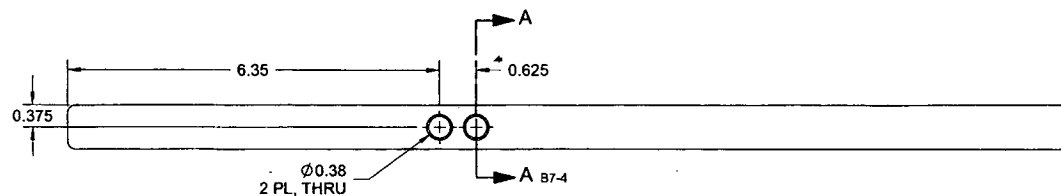


D4034-1 RIB

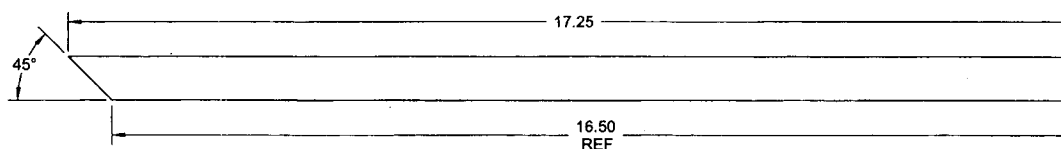
BREAK EDGE
0.030 X 45°
TYP



SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4034	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	UPPER RIB ASSY, BASKET BASE	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2010-03-12
[Signature]

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